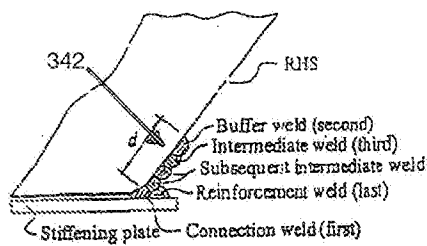


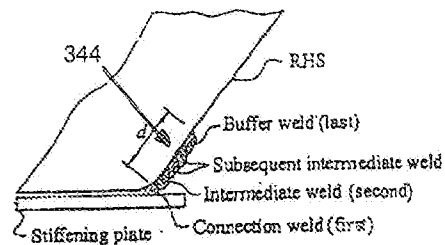
FIG. 28

Comparison between 150x50x4 specimens with and without seam weld

FIG. 34



(a) Backward bead deposit sequence



(b) Forward bead deposit sequence